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(54) **A CHIP SCREENING METHOD AND PLANT**

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WO-A1-84/02093 **US-A- 5 232 097**

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Description

[0001] This invention relates to the screening of wood chips and, especially, to the removal of the pin chips and to the dosing of them back into the process.

[0002] The objective of the chip screening is to free the chips from such shares of small-size and large-size fractions that could have a detrimental effect on the pulp making process. In the screening process, the large-size fractions (too big and too thick chips) are usually treated by means of a rechipper, for example, into smaller particles or crushed by means of a roller press into a form more suitable for the process. The finest fraction (the sawdust) causes problems in most processes, which is why every effort is made to purify the chips from it as well as possible. The next biggest fraction, the so-called pin chips, as such, constitutes quite a good raw material in terms of fibres, but a high content of pin chips is disadvantageous to some processes, e.g. to continuously operating digesters, as it may cause malfunctions in the process (e.g. blocks).

[0003] For the removal of pin chips, the same kind of devices are used as for the removal of sawdust, i.e. flat screens, vibrating screens, roll screens, disc screens and so forth. To the screening elements themselves, however, changes are made because of the larger particle size. Screening plants known in the prior art are described, for example, in Finnish patent specifications 79251 and 90019. If the subsequent process (a chemical or a mechanical pulp making process) sets strict restrictions on the maximal amount of pin chips, and if it is possible that the pin content of the material to be fed is high, the pin chips are usually separated by screening and stored in a separate bin. Then, the pin chips are dosed into the accepted fraction fed to the subsequent process, using a constant ratio. The plants designed for this purpose are reliable as such but represent, from an economical point of view, a considerable extra investment.

[0004] The characteristics of the method and the plant according to the present invention are set forth in claims 1 and 6.

[0005] On an average, the amount of pin chips among the chips to be screened is usually larger than the allowable amount, especially when the chips are bought from sawmills. The method according to the invention provides the same result at substantially lower costs. The pin chips are separated in the screening process but a maximum desired amount is dosed back among the chips due for the process immediately after the separation. Thus, no intermediate storage of the pin chips, and, consequently, no pin bin with auxiliary devices are needed in the method according to the invention. The screening can be optimised.

[0006] The invention and the details thereof will now be described in more detail with reference to the following drawings wherein

figure 1 shows the traditional way of separating and dosing pin chips using a flat screen,

figure 2 shows a method of separating and dosing pin chips in connection with thickness screening, figure 3 shows the method of separating and dosing pin chips according to the invention using a flat screen,

figure 4 shows the method of separating and dosing pin chips according to the invention in connection with thickness screening,

figure 5 shows the principles of the pin chip dosing method according to the invention in connection with a sectional feeder,

figure 6 shows a dosing screw and

figure 7 shows the use of a scraper conveyor for the dosing.

[0007] Figure 1 shows a screening system for separating pin chips and for re-dosing them so that the amount of pin chips among the chips that are to be led to the subsequent process remains constant. A flat screen 1 divides the input 2 into four parts. The large-size fraction 3 is led to a rechipper from which, once the re-chipping has been completed, it is conducted back to screen 1 via an air separating cyclone 5. The accepted fraction 6 is led to the subsequent process 7. The finest material 8, i.e. the sawdust, is usually led to a burning process. The pin chips 9 are conducted into a pin bin 10 from which a pin chip flow 11 of desired size is dosed back into the subsequent process 7. When the pin bin 10 becomes full, the pins are discharged from the bin among the sawdust 12, for example, to be burned.

[0008] In figure 2 is shown a thickness screening system wherein the large-size fraction 3, i.e. the chips that have crossed the first thickness screen 13, is led to a roller press 14. The chips 15 treated by the roller press are led directly to the subsequent process 7. The chips 16 that have penetrated the end part of the thickness screen are led directly to the subsequent process. The chips 17 that have penetrated the front part fall onto a sawdust screen 18. The particles 8 that have penetrated the sawdust screen are sawdust and are led to a burning process. The chips that have crossed the sawdust screen are pin chips 9 that are led into a pin bin and treated in the same way as in figure 1.

[0009] Figure 3 shows the pin chip dosing method according to the invention in connection with a flat screen. The pin chips 9 are led from the screen directly to a dosing apparatus 19 that doses only a certain amount 20 of pin chips into the subsequent process. The dosing apparatus 19 leads the surplus 21 of the pin chips among the sawdust 8. Alternatively, the surplus 21 of the pin chips is transported away from the screening plant, back to the chip pile, for example (if the variation in chip quality is only temporary), or, to a separate sawdust digesting process, for which the relevant pin fraction is excellent.

[0010] In figure 4, the pin chip dosing method accord-

ing to the invention is used in a thickness screening system. Pin chips 9 coming from a sawdust screen 18 are led to a dosing apparatus 19' which, in this case, is constituted by two screw conveyors. The dosing apparatus 19' operates in the same way as the dosing apparatus shown in figure 3.

[0011] Said dosing can be performed by means of many kinds of devices that feed only a certain amount of pin chips among the accepted chips at a certain rate. The rest of the pin chips are led among the sawdust or away from the screening process, as desired. It is essential that the dosing apparatus is set for dosing the appropriate chip amount. Some of the most common ways of performing this kind of dosing are described in the following. In a so-called sectional feeder, for example, the pin chips are led into the feeding chute 22 of the sectional feeder 19 (figure 5). The dosing apparatus can be set to dose a desired amount 20 of pins into the subsequent process by adjusting the size of the sections 23 and the rate of rotation of the rotor 24. The rest 21 of the pin chips fall over the lower edge 25 of the feeding chute 22.

[0012] Correspondingly, dosing can be performed for example by means of two screw conveyors (figure 6). A desired amount of pin chips 20 is extracted by means of adjusting the speed of rotation of the lower screw conveyor 26. The upper screw conveyor 27 transports the rest 21 of the pin chips to a separate discharge opening 30 from which they are conducted, for example, among the sawdust. Dosing can be also performed by means of a scraper conveyor (figure 7), for example by adjusting the rate of speed of the lower scraper conveyor 28 to control the amount of pin chips 20 led into the subsequent process. It is also possible to place a screw conveyor under the scraper conveyor 29, to operate according to figure 6.

[0013] If the input of the screening process varies in quantity, the input or the output of the screening process can be measured and, correspondingly, the amount of pin chips led to the subsequent process can be adjusted. Thus, the ratio of the pin chips to the total amount of chips led to the subsequent process remains constant all the time. If the input of screening plant is constant, a constant amount of pin chips can be dosed.

[0014] The term "pin chip" is defined, for example, in standard SCAN-CM 40:94.

Claims

1. A wood chip screening method wherein the pin chips (9) are separated from the rest of the chips and dosed among chips that are to be led to a subsequent process (7) so that the share of the pin chips (9) relative to the total amount of chips (7) does not exceed a desired value, **characterised in that** a desired amount (20) of the pin chips separated in the screening process, once the screening

process has been completed, is led among the chips that are to be led to a subsequent chemical or mechanical pulp making process (7) without intermediate storage.

2. A chip screening method as defined in claim 1, **characterised in that** the amount of pin chips (20) led among the chips that are to be led to the subsequent process (7) is defined by means of a dosing apparatus (19, 19', 26, 28).
3. A chip screening method as defined in claim 1, **characterised in that** the amount of pin chips (20) led among the chips that are to be led to the subsequent process (7) is defined by measuring the amount of chips (2) fed into the screening process.
4. A chip screening method as defined in claim 1, **characterised in that** the amount of pin chips (20) dosed among the chips that are to be led to the subsequent process is defined by measuring the amount of chips fed into the subsequent process (7) from the screening process.
5. A chip screening method as defined in any one of claims 1 to 4, **characterised in that** the amount of pin chips (21) exceeding the desired amount (20) is led among the sawdust or to the chip pile preceding the screening process or to a separate pin pile.
6. A plant for screening wood chips and for leading them to a subsequent process (7), which plant comprises one or more screening devices (1, 18) and means for dosing the pin chips (9) among chips (7) that are to be led to the subsequent process, **characterised in that** the means (19, 19', 26, 28) for dosing the pin chips (9) among the chips (7) that are to be led to a subsequent chemical or mechanical pulp making process are placed immediately after the screening devices (1, 18) or the conveyors (27, 29) coming therefrom.

Patentansprüche

1. Verfahren zum Sieben von Holzspänen, bei dem die Nadelspäne (9) vom Rest der Späne getrennt und unter Späne dosiert werden, die zu einem nachfolgenden Prozess (7) geleitet werden sollen, so dass der Anteil der Nadelspäne (9) relativ zur Gesamtmenge von Spänen (7) einen gewünschten Wert nicht übersteigt, **dadurch gekennzeichnet, dass** eine gewünschte Menge (20) von den Nadelspänen, die bei dem Siebprozess getrennt wird, sobald der Siebprozess abgeschlossen worden ist, ohne Zwischenspeicherung unter die Späne geleitet wird, die zu einem anschließenden chemischen

oder mechanischen Pulpenherstellungsprozess (7) geleitet werden sollen.

2. Verfahren zum Sieben von Spänen nach Anspruch 1, 5
dadurch gekennzeichnet, dass
 die Menge von Nadelspänen (20), die unter die Späne geleitet wird, die zu dem nachfolgenden Prozess (7) geleitet werden sollen, mittels einer Dosier-
 vorrichtung (19, 19', 26, 28) definiert wird. 10
3. Verfahren zum Sieben von Spänen nach Anspruch 1,
dadurch gekennzeichnet, dass
 die Menge von Nadelspänen (20), die unter die Späne geleitet wird, die zu dem nachfolgenden Prozess (7) geleitet werden sollen, durch Messen der
 Menge von Spänen (2), die dem Siebprozess zuge-
 führt wird, definiert wird. 15
4. Verfahren zum Sieben von Spänen nach Anspruch 1,
dadurch gekennzeichnet, dass
 die Menge von Nadelspänen (20), die unter die Späne dosiert wird, die zu dem nachfolgenden Prozess geleitet werden sollen, durch Messen der
 Menge von Spänen, die dem nachfolgenden Prozess (7) von dem Siebprozess zugeführt wird, definiert wird. 20
5. Verfahren zum Sieben von Spänen nach einem der Ansprüche 1 bis 4,
dadurch gekennzeichnet, dass
 die Menge von Nadelspänen (21), die die ge-
 wünschte Menge (20) übersteigt, unter den Säge-
 staub oder zu dem Spänehaufen, der dem Siebpro-
 zess vorhergeht, oder zu einem separaten Späne-
 haufen geleitet wird. 25
6. Anlage zum Sieben von Holzspänen und zum Lei-
 ten derselben zu einem nachfolgenden Prozess (7),
 wobei die Anlage eine oder mehrere Siebeinrich-
 tungen (1, 18) und Mittel zum Dosieren der Nadel-
 späne (9) unter Späne (7), die zu dem nachfolgen-
 den Prozess geleitet werden sollen, umfasst,
dadurch gekennzeichnet, dass
 die Mittel (19, 19', 26, 28) zum Dosieren der Nadel-
 späne (9) unter die Späne (7), die zu einem nach-
 folgenden chemischen oder mechanischen Pulpen-
 herstellungsprozess geleitet werden sollen, unmit-
 telbar nach den Siebeinrichtungen (1, 18) oder den
 von diesen kommenden Fördereinrichtungen (27,
 29) platziert sind. 30

Revendications

1. Procédé de triage de copeaux de bois dans lequel

les copeaux-allumettes (9) sont séparés du reste des copeaux et dosés parmi des copeaux qui doi-
 vent être emmenés vers un processus ultérieur (7)
 de sorte que la proportion de copeaux-allumettes
 (9) par rapport à la quantité totale de copeaux (7)
 ne dépasse pas une valeur souhaitée, **caractérisé**
en ce qu'une quantité souhaitée (20) des copeaux-
 allumettes séparés dans le processus de triage,
 une fois que le processus de triage est achevé, est
 emmenée parmi les copeaux qui doivent être em-
 menés vers un processus de fabrication de pâte
 mécanique ou chimique ultérieur (7) sans stockage
 intermédiaire.

2. Procédé de triage de copeaux de bois selon la re-
 vendication 1, **caractérisé en ce que** la quantité de
 copeaux-allumettes (20) emmenée parmi les co-
 peaux qui doivent être emmenés vers un processus
 ultérieur (7) est définie au moyen d'un appareil de
 dosage (19, 19', 26, 28). 20
3. Procédé de triage de copeaux de bois selon la re-
 vendication 1, **caractérisé en ce que** la quantité de
 copeaux-allumettes (20) emmenée parmi les co-
 peaux qui doivent être emmenés vers un processus
 ultérieur (7) est définie en mesurant la quantité de
 copeaux (2) fournie dans le processus de triage. 25
4. Procédé de triage de copeaux de bois selon la re-
 vendication 1, **caractérisé en ce que** la quantité de
 copeaux-allumettes (20) dosée parmi les copeaux
 qui doivent être emmenés vers un processus ulté-
 rieur est définie en mesurant la quantité de copeaux
 fournie dans le processus ultérieur (7) à partir du
 processus de triage. 30
5. Procédé de triage de copeaux de bois selon l'une
 quelconque des revendications 1 à 4, **caractérisé**
en ce que la quantité de copeaux-allumettes (21)
 dépassant la quantité souhaitée (20) est emmenée
 parmi la sciure ou vers la pile de copeaux précédant
 le processus de triage ou vers une pile de copeaux-
 allumettes. 35
6. Usine pour le triage de copeaux de bois et pour les
 emmener vers un processus ultérieur (7), laquelle
 usine comprend un ou plusieurs dispositifs de triage
 (1, 18) et des moyens pour doser les copeaux-allu-
 mettes (9) parmi les copeaux (7) qui doivent être
 emmenés vers le processus ultérieur, **caractérisée**
en ce que les moyens (19, 19', 26, 28) pour doser
 les copeaux-allumettes (9) parmi les copeaux (7)
 qui doivent être emmenés vers un processus de fa-
 brication de pâte mécanique ou chimique ultérieur
 sont placés immédiatement après les dispositifs de
 triage (1, 18) ou les convoyeurs (27, 29) venant de
 ceux-ci. 40

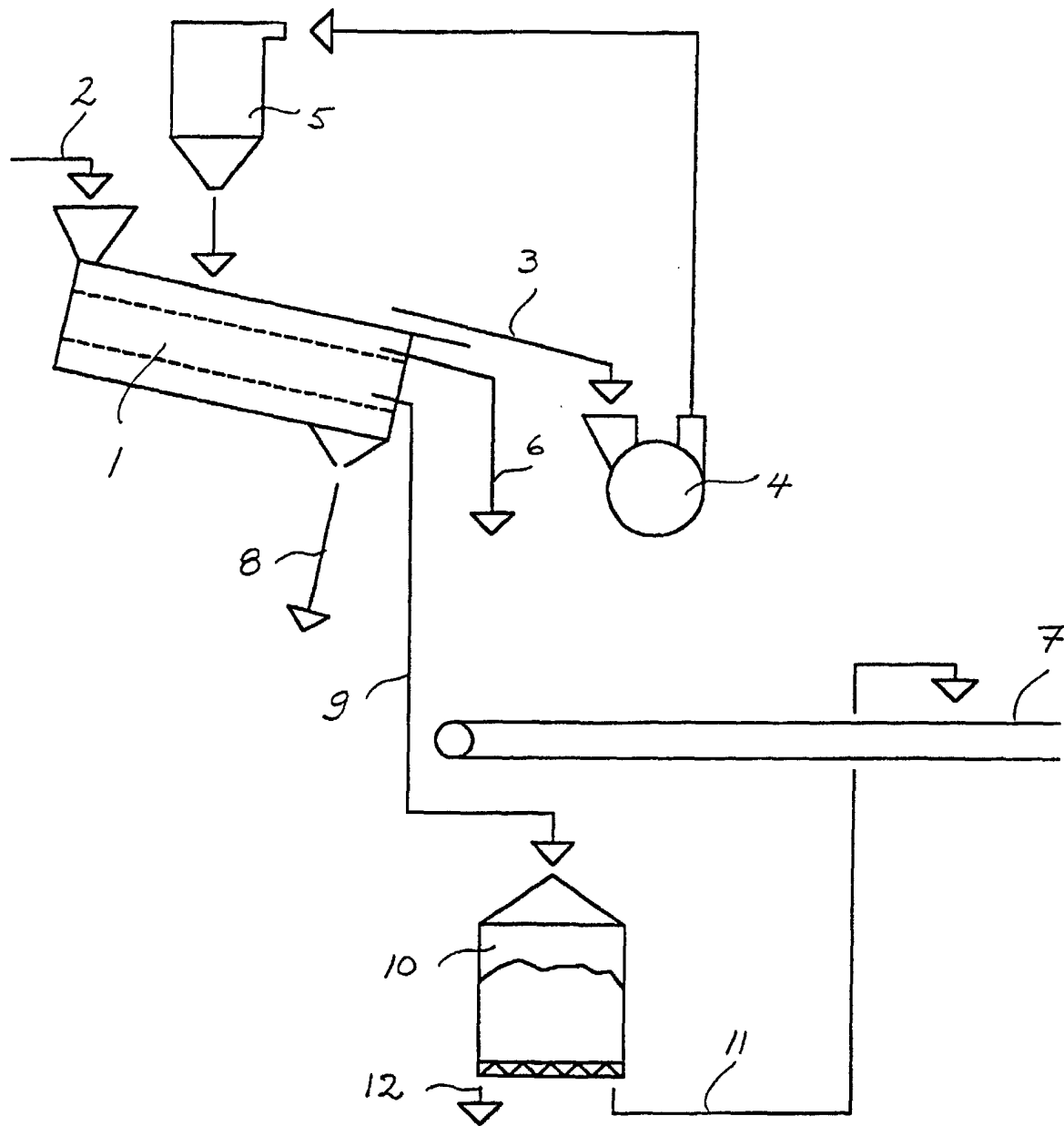


Fig. 1

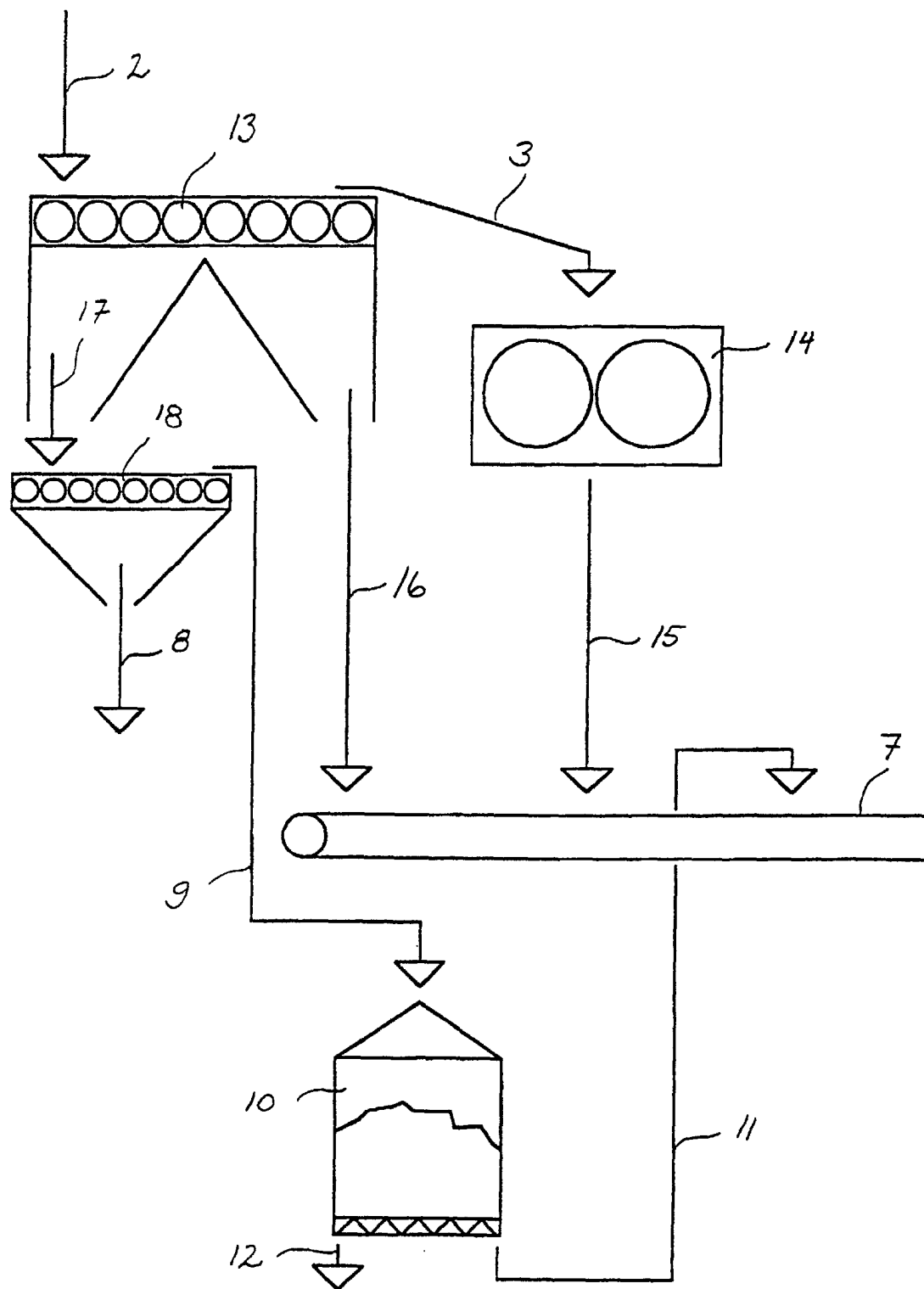


Fig. 2

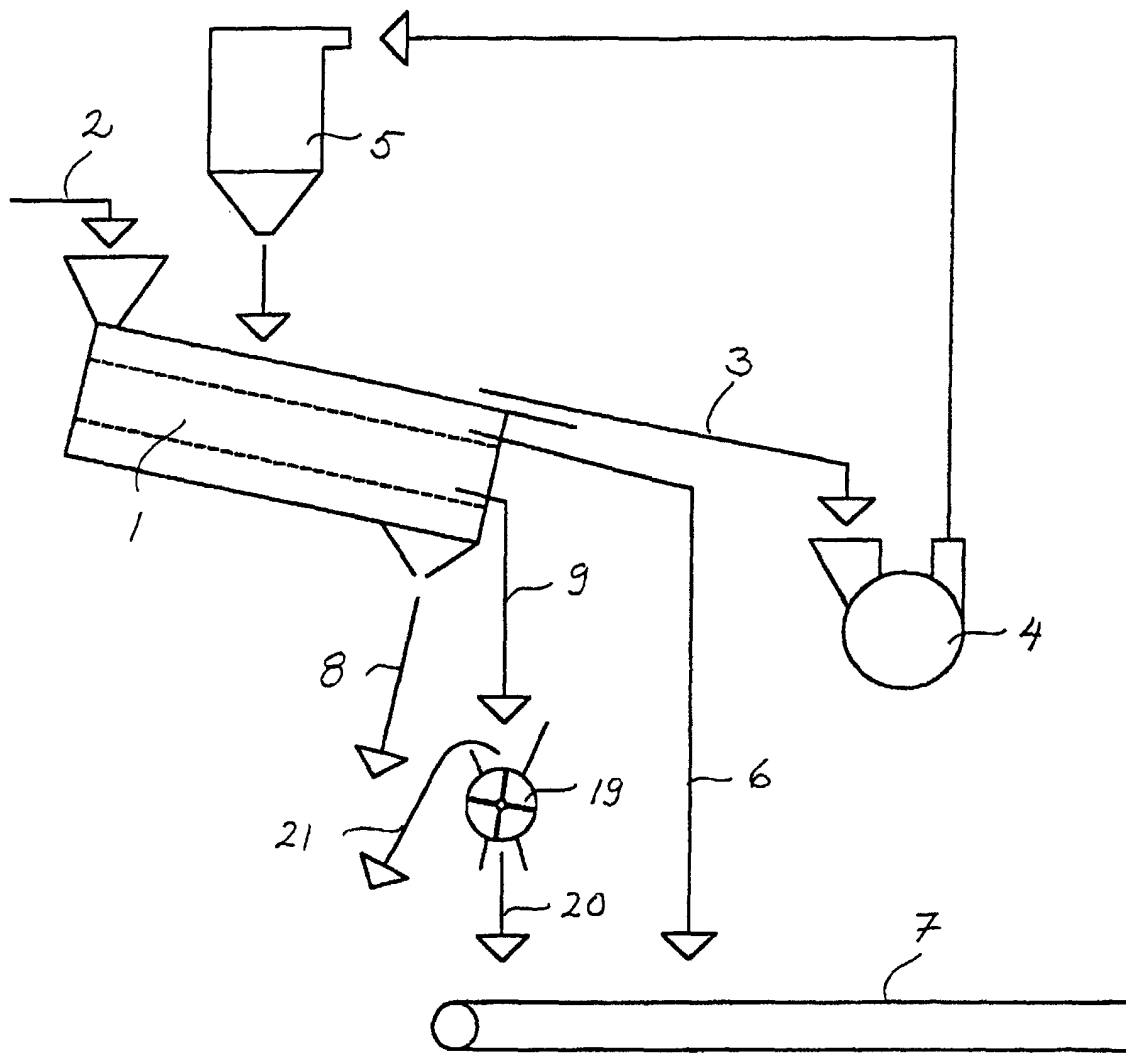


Fig. 3

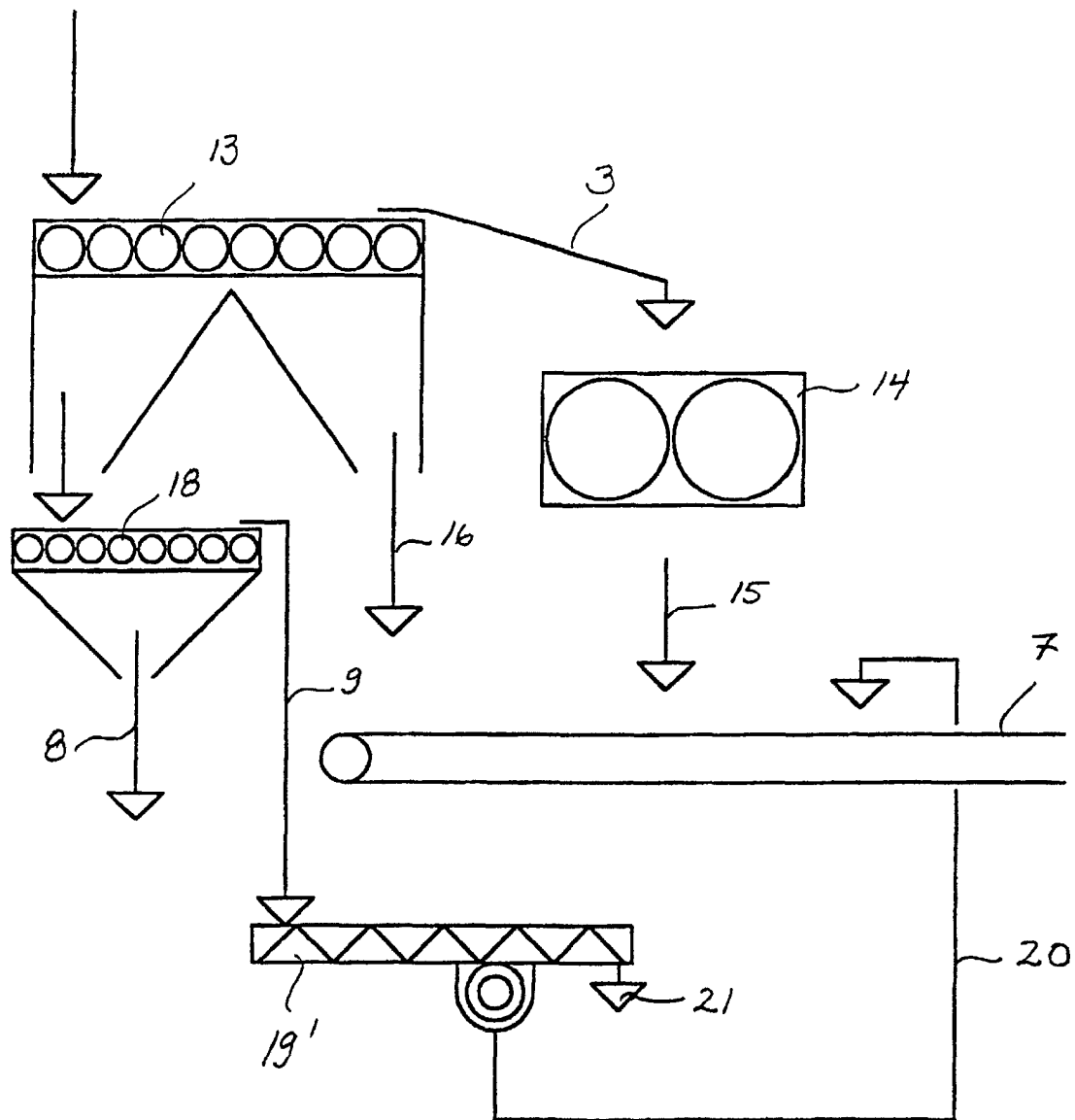


Fig. 4

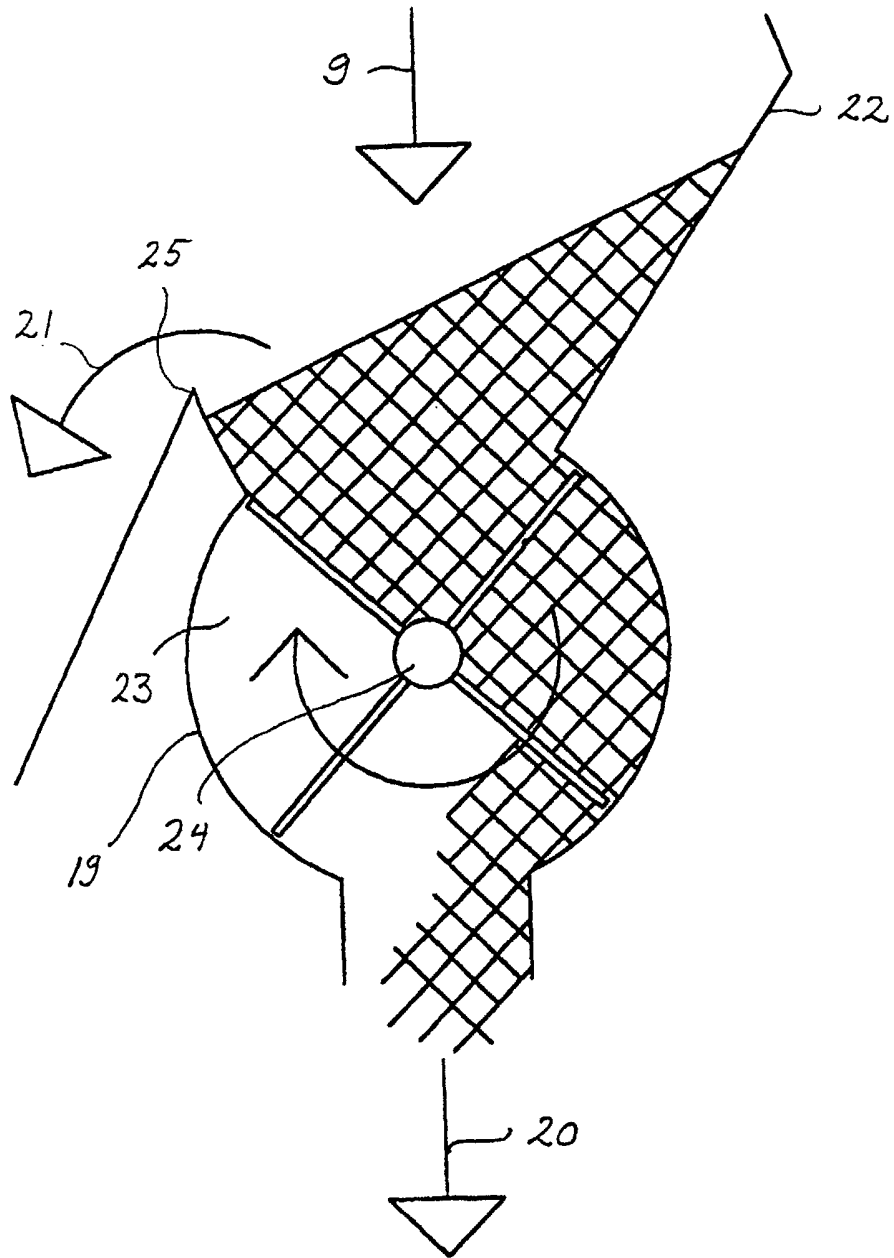


Fig. 5

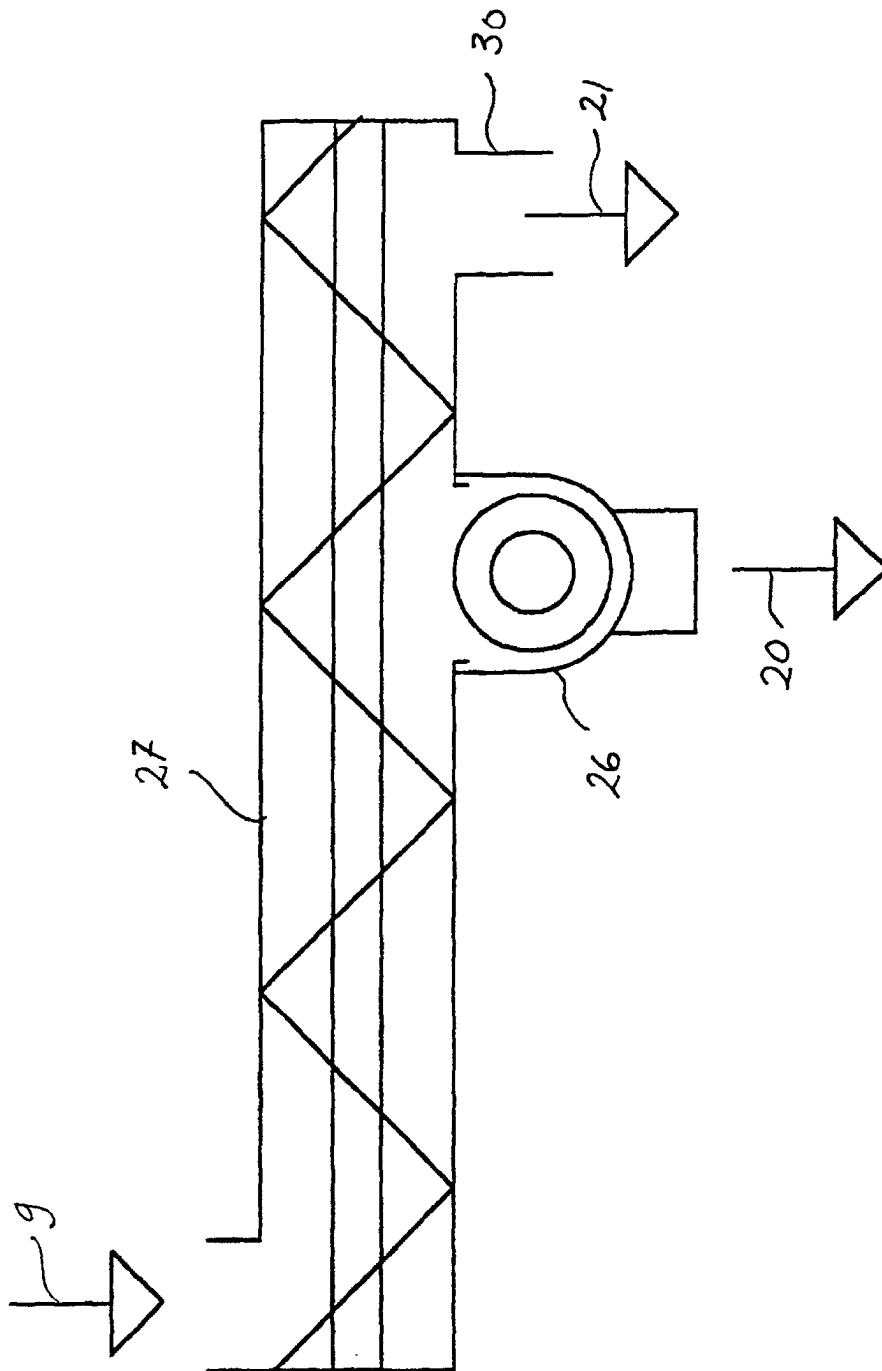


Fig. 6

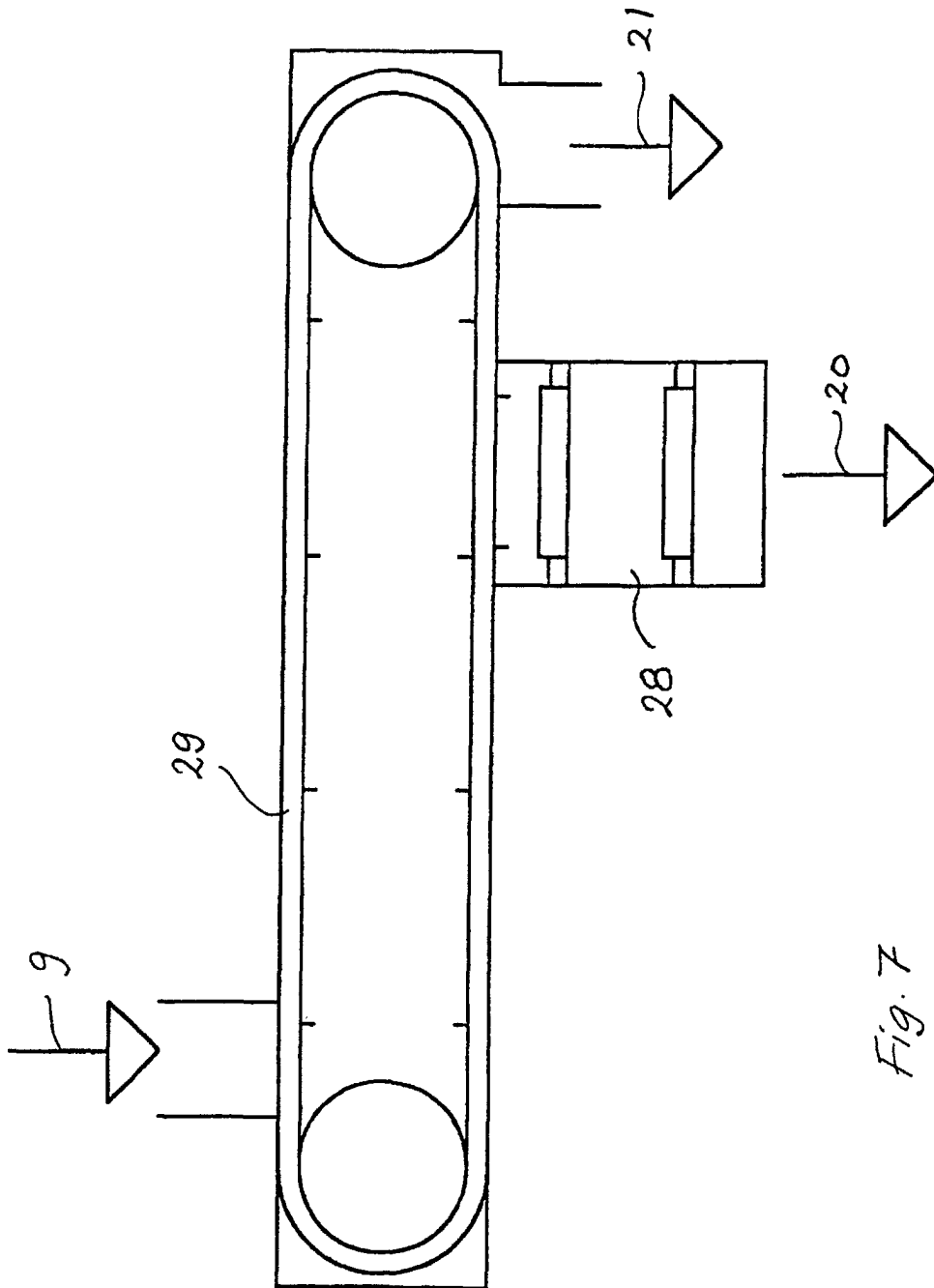


Fig. 7